

Work Order ID 82371

March-29-12 3:12:55 PM

82371

~~PRELIMINARY ISSUE~~

120404
Page 1

Item ID: D4628-5
Revision ID: ~~PRELIM~~
Item Name: Liner, Outboard

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Start Date: 3/29/12 Start Qty: 1.00 *1*
Required Date: 4/02/12 Req'd Qty: 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: Process Plan:  Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp



Draw Nbr	Revision Nbr
D4628	PA 22 REV. A 12.04.04

100

0.00

100

Waterjet
FLOW CNC Waterjet

Memo
1-Cut as per dwg D4628
Prog rev: 
Dwg rev: 

0.00

Kydey

2-Deburr as per dwg

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC
Quality Control

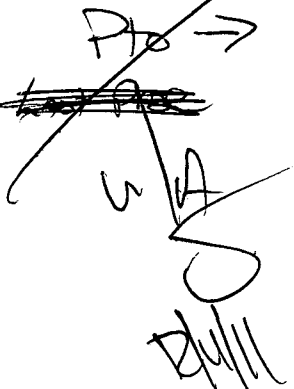
Memo

0.00

1B12-3-30

①

1B12-3-30



W/O: 82371		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4628-5 PAR #: _____ Fault Category: Small Part NCR: Yes No DQA: _____ Date: _____
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/04	#130	Parts were scrapped at Assembly. R.L. improper installation	S 12/04/04 as 7042	Remark: As per DWG D4628-5 B	CH +1 12/04/04		S 12/04/04 as 7042	S 12/04/04

NOTE: Date & initial all entries

Work Order ID 82371

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82371

Page 2

Item ID: D4628-5
Revision ID: PRELIM
Item Name: Liner, Outboard

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 3/29/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/02/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>inspects to Pdz</i> <i>Don or by</i> <i>Suzuki (K)</i>						
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> Memo	0.00 0.00	<i>u 1204.9</i>						
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	<i>12/4/10</i>						

POSITIVE RECALL

EFFECTIVE *12/3/12* AUTH *u*

RELEASED *12/4/12* DATE *12/4/12*

ECN#12558

u 1204.9

Picklist Print

March-29-12 3:12:54 PM

Page 1

Work Order ID: 82371

Parent Item: D4628-5

Parent Item Name: Liner, Outboard

Start Date: 3/29/12

Required Date: 4/02/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 12.03.29 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	796.2216	6.63	6.9789474			

Kydex steel grey

B12-3-30

Location

Loc Qty

Loc Code

therm

796.2215592

111807

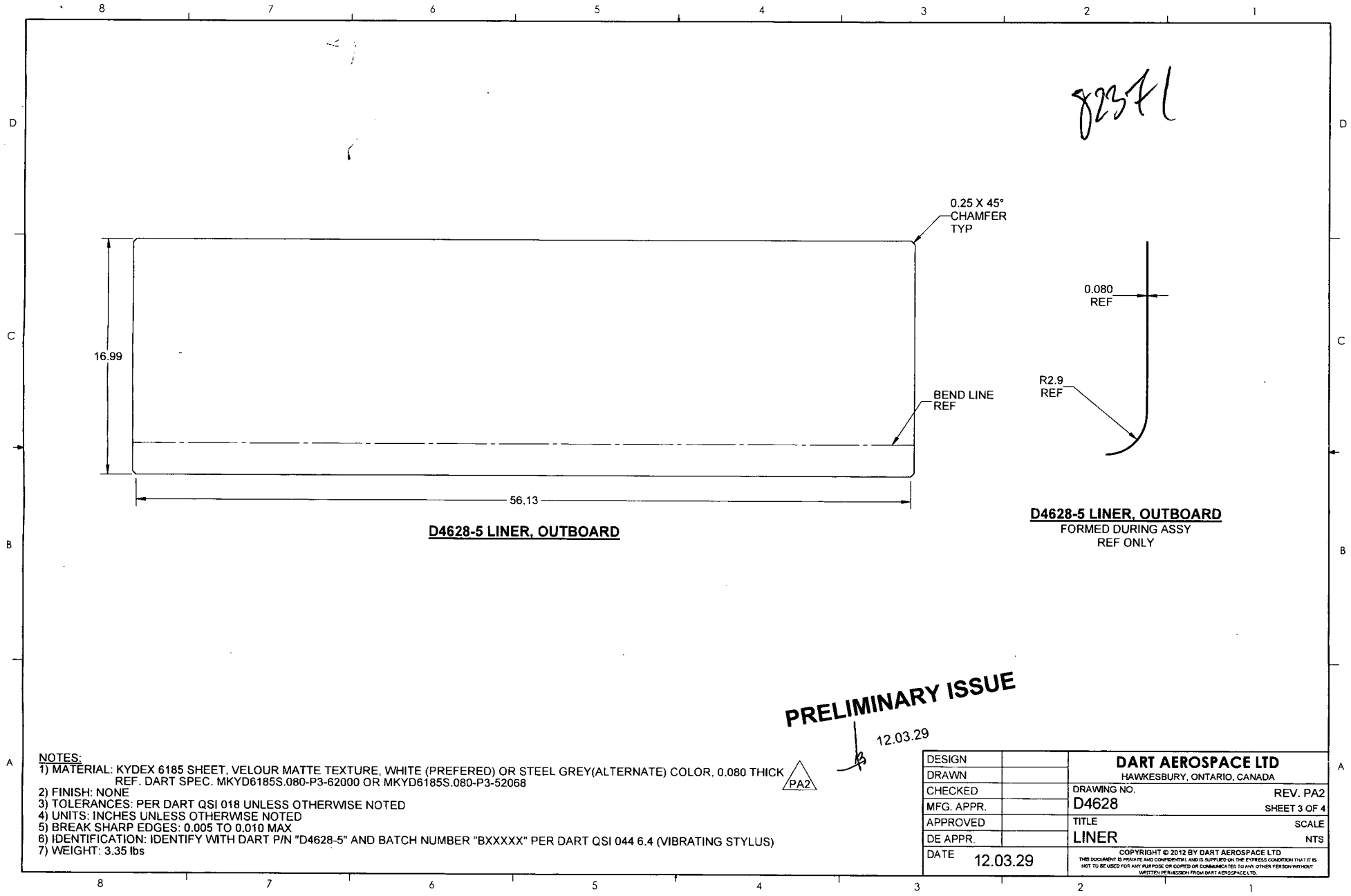
10.4896282

119476

785.731931

119476

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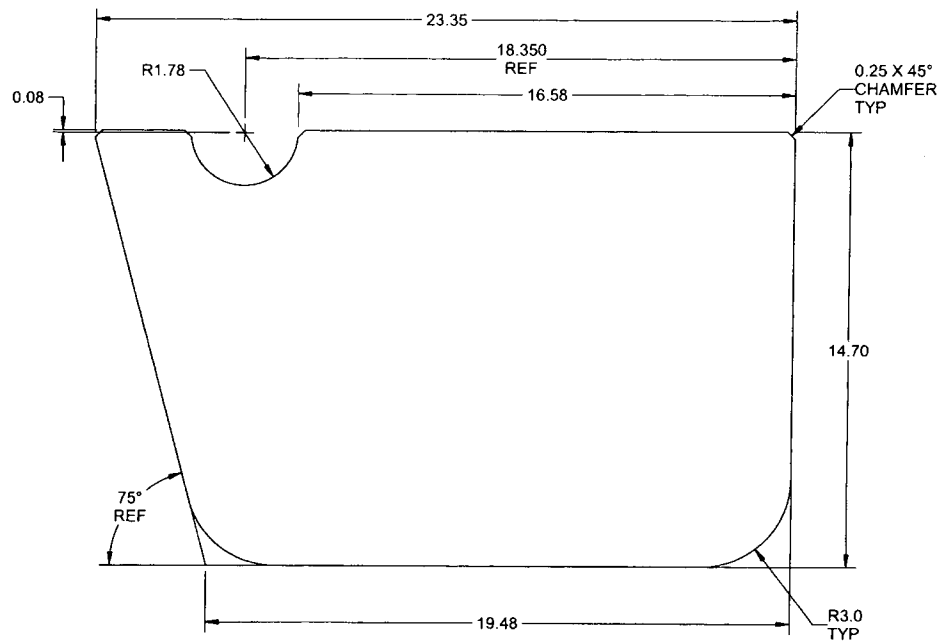
NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-5" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 3.35 lbs

PRELIMINARY ISSUE

12.03.29

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4628	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LINER	NTS
DATE	12.03.29	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4628-1 LINER, FACE

RELEASED
2012-04-04

82371

NOTES:

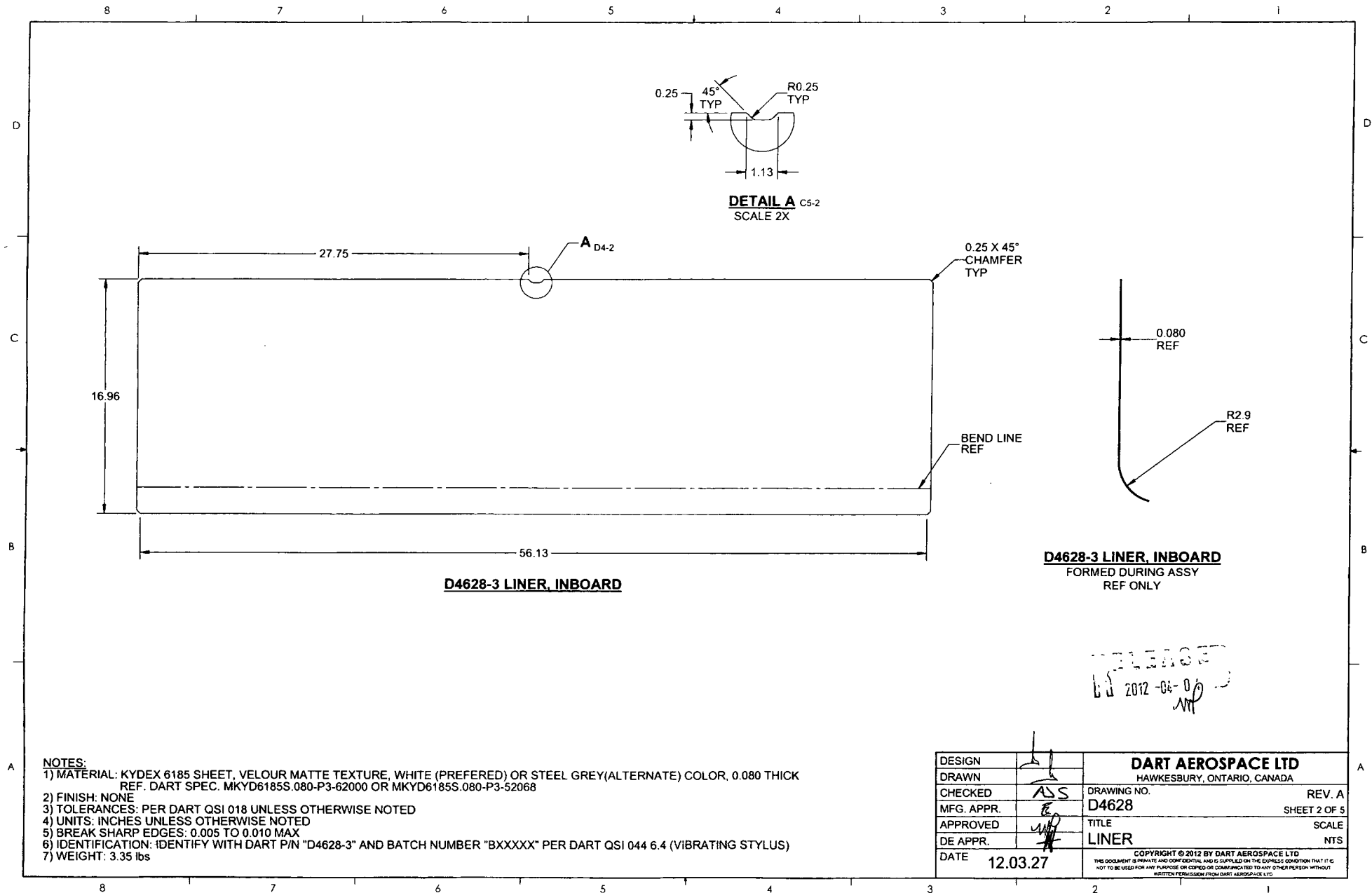
- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERRED) OR STEEL GREY (ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-1" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 1.07 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	12.03.27
DESIGN			
DRAWN			
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4628** REV. A
SHEET 1 OF 5
TITLE **LINER** SCALE NTS

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16.99

56.13

D4628-5 LINER, OUTBOARD

0.25 X 45°
CHAMFER
TYP

BEND LINE
REF

0.080
REF

R2.9
REF

D4628-5 LINER, OUTBOARD
FORMED DURING ASSY
REF ONLY

2012-04-04

- NOTES:**
- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK
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 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-5" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
 - 7) WEIGHT: 3.35 lbs

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

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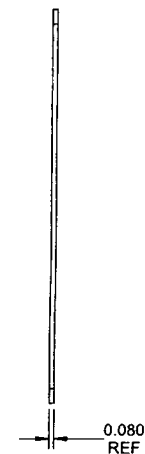
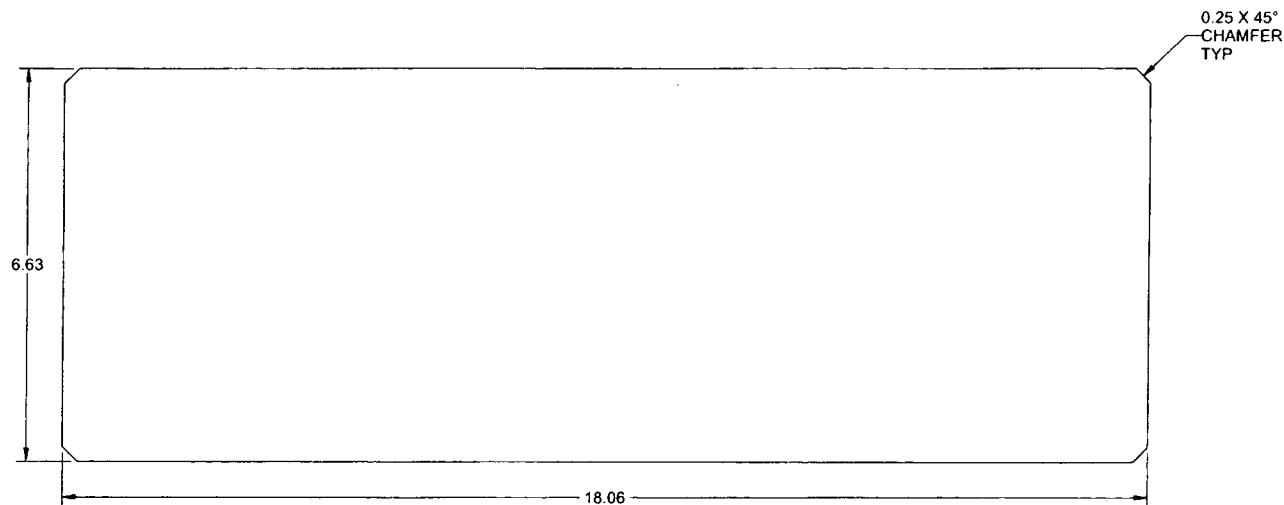
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D4628-7 LINER, LID

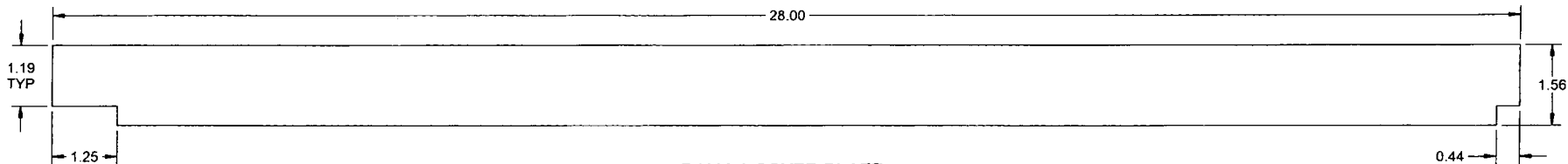
RELEASED
2012-04-04

NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERRED) OR STEEL GREY (ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-7" AND BATCH NUMBER "BXXXXX" PER DART_QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 0.42 lbs

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8 7 6 5 4 3 2 1



D4628-9 COVER PLATE

RELEASED
2012-04-04
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

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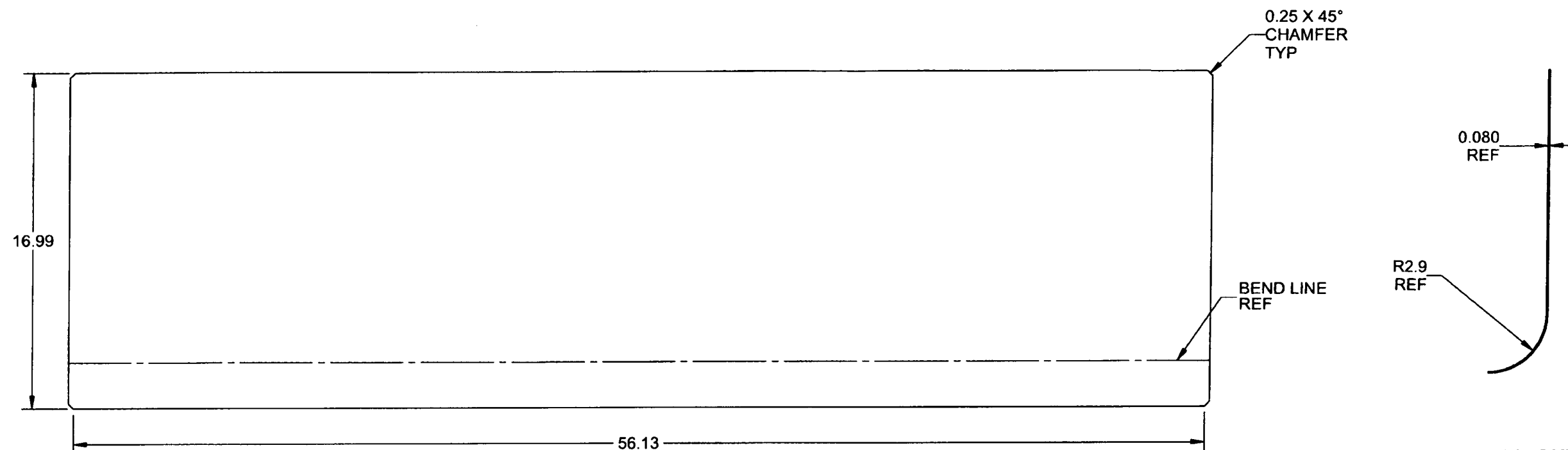
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16328

**D4628-5 LINER, OUTBOARD****D4628-5 LINER, OUTBOARD**
FORMED DURING ASSY
REF ONLYRELEASED
2012-04-04
MP**NOTES:**

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- 7) WEIGHT: 3.35 lbs

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